

Date: Monday, 27/08/2007 2:53:57 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.		Drawing Name	: DISASSEMBLE	
Job Number	: 34267		Part Number	: D3562042	
Estimate Number	: 10804		Drawing Number	: D412-630-034	
P.O. Number	:		Project Number	:	
This Issue	: 27/08/2007	S.O. No. :	Drawing Revision	:	
Prsht Rev.	: NC		Material	:	
First Issue	: 27/08/2007	Type	: LARGE FAB ASSY		
Previous Run	: 34266		Due Date	: 03/09/2007 Qty: 1 Um: Each	
Written By	:				
Checked & Approved By	:				
Comment	:				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1  <b>Comment: PACKAGING RESOURCE #1</b>
2.0	D412630034	HELI ACCESS STEP, LH FOLDING  <b>Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) HELI ACCESS STEP, LH FOLDING</b>
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1  <b>Comment: SMALL &amp; MEDIUM FAB RESOURCE 1</b>
4.0	QC5	DISASSEMBLE D2803/D2804 BRACKET ASS'YS  <b>Comment: INSPECT WORK TO CURRENT STEP</b>
5.0	PACKAGING 1	PACKAGING RESOURCE #1  <b>Comment: PACKAGING RESOURCE #1 REPACKAGE AS "D3562-041" RESTOCK PARTS</b>

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## Process Sheet

Customer: CC-DAR01 -Dart Aerospace Ltd.

Drawing Name: DISASSEMBLE

Job Number: 34267

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description :

get 32716  
for parts to return to 5th

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

REPLACEMENT STEP WELDMENT FOR B/N 27271

ISSUE RED DECAL - D412-630-033 B34267

NEW PAPERWORK REQ'D

11/08/27

Job Completion



QC21 FINAL inspection w/o release 11/08/28

11/08/28

Date: Thursday, 5/31/2007 7:23:02 AM  
 User: Kim Johnston

Acq DISAS D412630 28/08 26  
 Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HELI-ACCESS STEP RH (FOLDING)	
Job Number	: 32716		Part Number	: D412630034	
Estimate Number	: 12568		Drawing Number	: IIN D412-630 REV K	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 5/31/2007 S.O. No. : N/A		Drawing Revision	: K	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 6/30/2007 Qty: 5	
Previous Run	: 32714		Um:	Each	
Written By	: JLM				
Checked & Approved By	: 07.05.31				
Comment	: Est. Rev.A New Issue 06-11-08 JLM				

## Additional Product

REFERENCE ONLY

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
	Comment: DOCUMENT CONTROL	Photocopy bluefile & create labels per PPP D412-630-034 CHG002	KS 07.06.05
2.0	D2012107	Clevis	
	Comment: Qty.: 1.0000 Each(s)/Unit	Total : 6.0000 Each(s)	
	Clevis		
	Pick:		
	Qty	Part Number	Description
1	D2012-107	Clevis	Batch 3255/ 50
3.0	D2803042	Bracket Assembly	
	Comment: Qty.: 1.0000 Each(s)/Unit	Total : 6.0000 Each(s)	
	Bracket Assembly		
	Pick:		
	Qty	Part Number	Description
1	D2803-042	Bracket Assembly RH	Batch 27283 26564 27392
4.0	D2804042	Bracket Assembly	
	Comment: Qty.: 1.0000 Each(s)/Unit	Total : 6.0000 Each(s)	
	Bracket Assembly		
	Pick:		
	Qty	Part Number	Description
1	D2804-042	Bracket Assembly RH	Batch 27409 27284 7/7/11 50

Date: Thursday, 5/31/2007 7:23:02 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 32716

Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D2807 Support Prop



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Support Prop

Pick:

Qty	Part Number	Description
2	D2807	Gas Spring

Batch: 1529828, (2) SD

6.0 D2818 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
2	D2813	Washer

Batch: 1529396, (2) SD

7.0 D3562042 STEP ASSEMBLY, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Step Weldment LH

Pick:

Qty	Part Number	Description
1	D3562-042	Step Weldment RH

Batch: 1532781 SD

8.0 D33951 Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description
4	D3395-1	Bushing

Batch: 1528455, 26720, 32783, (3) SD 4 \* XJX

9.0 AN3C21A BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description
2	AN3C21A	Bolt

Batch: 1101189, 7/7/1159

Date: Thursday, 5/31/2007 7:23:02 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 32716

Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 AN8C16

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description
2	AN8C16	Bolt

Batch

*M102736, ② SP*

11.0 AN310C8

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
2	AN310C8	Nut

Batch

*M102728, ② SP ③ M1021679,*

12.0 MS24665302

Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Cotter Pin

Pick:

Qty	Part Number	Description
2	MS24665-302	Cotter Pin (or AN380C3-4)

Batch

*M1027991, SP*

13.0 NAS1515H3

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 36.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
6	NAS1515H3	Washer

Batch

*M102983, SP*

14.0 NAS1515H5L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description
4	NAS1515H5L	Washer

Batch

*M1029679, 7/7/11 SP*

Date: Thursday, 5/31/2007 7:23:03 AM  
User: Kim Johnston

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Job Number: 32716



Job Number:

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Part Number: D412630034

Seq. #: Machine Or Operation:

Description:

15.0 NAS1515H8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
4	NAS1515H8	Washer

Batch

M102067

SD

16.0 MS210433

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
4	MS21043-3	Nut

Batch

M104679

SD

17.0 MS24693C280

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description
2	MS24693-C280	Screw (or MS24694-C565)

Batch

M101390

7/2/11 SG

18.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: M104929

COAT exposed HARDWARE WITH LPS PROCYON.

A/R LPS PROCYON BATCH: M17045

MF 07-07-18

5

19.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 07/07/11 SG

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 32716

Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation:

Description :

20.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0 D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bushing

Pick: Packing Kit

Qty	Part Number	Description
2	D2806-1	Bushing

Batch

B27285

28565

29393

42

2

SD

6x

22.0 D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bushing

Pick: Packing Kit

Qty	Part Number	Description
2	D2806-3	Bushing

Batch

A26162

27286

28163

SD

Y

23.0 D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Strut

Pick: Packing Kit

Qty	Part Number	Description
1	D2810-5	Strut

Batch

B27103

B27287

29395

SD

1

24.0 D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Spacer

Pick: Packing Kit

Qty	Part Number	Description
2	D3396-1	Spacer

Batch

B27290

B27290

B27290

SD

2

25.0 AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description
1	AN4C6A	Bolt

Batch

1104936

1104936

1104936

SD

1

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 32716

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 AN4C6A Bolt

26.0 AN4C10A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	AN4C10A	Bolt	1102273

27.0 AN4C15A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	AN4C15A	Bolt	1102959

28.0 AN44C7A Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	AN44-C7A	Eyebolt	1101771

29.0 AN5C15A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	AN5C15A	Bolt	1100229

1 2 3 4 ✓

30.0 NAS1515H4 Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 42.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description	Batch
7	NAS1515H4	Washer	1101428

5 6 7 8 ✓ 1/1/23 sd

Date: Thursday, 5/31/2007 7:23:03 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 32716

Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation:

Description :

31.0 NAS1515H5 Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 42.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number  
7 NAS1515H5

Description  
Washer

Batch

M1041885

1

SD

✓

32.0 MS210434 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number  
4 MS21043-4

Description  
Nut

Batch

M1041936

4

SD

✓

33.0 MS210435 Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 18.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number  
3 MS21043-5

Description  
Nut

Batch

M1041918

3

✓

7/7/23 5025

34.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



7/7/23

Comment: INSPECT 100% KITS FOR COMPLETENESS

7/7/23 (5)

35.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-034

Location: A

PPP Rev: A

7/7/23 (5)

7/7/23

36.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

7/7/23 (5)

Job Completion



7/7/23